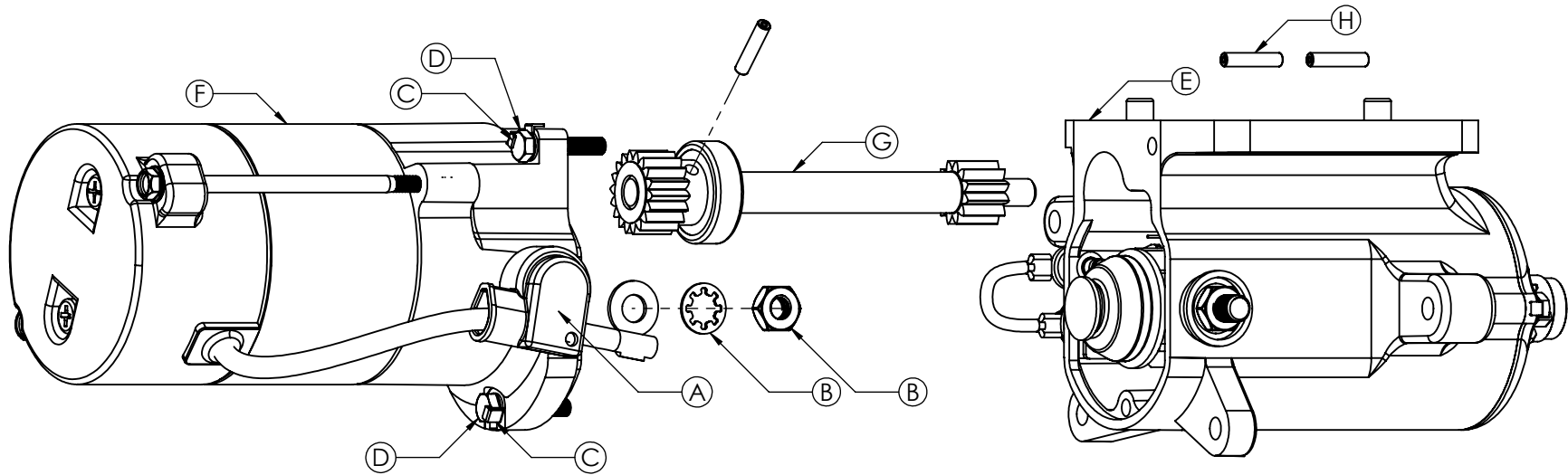


**SHEAR PIN REPLACEMENT INSTRUCTIONS**

1. REMOVE STARTER FROM AIRCRAFT.
2. LIFT & SLIDE THE INSULATING BOOT (A) BACK ALONG THE MOTOR LEAD. REMOVE M8 NUT AND WASHER (B) USING 13mm WRENCH. REMOVE MOTOR LEAD FROM STUD.
3. BEND LOCKING TABS (C) AWAY FROM SCREW HEADS. REMOVE M5 HEX HEAD SCREWS (D) USING 8mm WRENCH.
4. SEPARATE SOLENOID SECTION (E) FROM MOTOR SECTION (F). ENSURE SOLENOID PLUNGER REMAINS INSIDE SOLENOID SECTION (E).
5. EXTRACT LAY SHAFT (G).
6. TAP OUT OLD SHEAR PIN FROM LAY SHAFT (G) AND REPLACE WITH NEW SPARE SHEAR PIN (H) FROM TOP OF SOLENOID SECTION (E) OR WITH SKY-TEC P/N 25024 OR WITH SPIROL CLDP .156x.750 MCP.
7. REASSEMBLE STARTER.
8. APPLY HIGH STRENGTH THREAD LOCK COMPOUND AND TORQUE M5 HEX HEAD SCREWS (D) TO 55 INCH-LBS. BEND LOCKING TABS (C) BACK INTO PLACE ON SCREW HEADS.
9. TORQUE M8 NUT AND WASHER (B) TO 75 INCH-LBS.
10. SLIDE AND RESEAT INSULATING BOOT (A).
11. REINSTALL STARTER ON AIRCRAFT PER SKY-TEC INSTALLATION DRAWING 25001.

**REVISIONS**

| ZONE | REV. | DESCRIPTION           | DATE       | APPROVED |
|------|------|-----------------------|------------|----------|
|      | A    | SCREWS UPDATED TO HEX | 11/03/2005 | EC       |
|      | B    | REDRAWN               | 7/31/2015  | RVC      |



**Sky-Tec Partners, Ltd.**  
Granbury, Texas

**SHEAR PIN REPLACEMENT**

|  |                      |                                |
|--|----------------------|--------------------------------|
| SCALE:<br><b>1:2</b>                               | MATERIAL:<br>N/A     | FINISH:<br>N/A                 |
| DIMENSIONS IN INCHES<br>UNLESS OTHERWISE SPECIFIED |                      | DRAWN BY:<br><b>E. CHIAPPE</b> |
|  |                      | DATE:<br><b>10/30/2003</b>     |
| TOLERANCES:  |                      |                                |
| ANGLES<br>$\pm 1^\circ$                            | 0.X<br>$\pm 0.050$   | 0.XX<br>$\pm 0.030$            |
|  | 0.XXX<br>$\pm 0.010$ |                                |
| SHEET:<br><b>1/1</b>                               |                      | PART NO:<br><b>25099</b>       |
|  |                      | REV:<br><b>B</b>               |